

Work Order ID 70725

Tuesday, June 14, 2011 7:39:38 AM

Page 1

Item ID: D2012-105

Accept

Setup Start

Revision ID:

Stop

Item Name: Arm

Start Date: 6/13/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2012-105

E

100

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Punch to length as per Dwg D2012-105 & template D2012-105T1

32.140

SB 11/6/05

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr

SB 11/10/13 (10)

120

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

SB 11/6/13

(40)

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Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:00
320 OF
3:30

10X Ø M-f 11/10/18

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

10
MEASURED
& COUNTED
JL 11/10/19

150

Identify as per dwg & Stock Location: ST 229

0.00



Packaging

Packaging

Memo

0.00

10X - Sp 11-10-19.

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Item ID: D2012-105

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 6/13/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

6/10/19 [Signature]
mf
6-10-19

Picklist Print

Tuesday, June 14, 2011 7:39:35 AM

Page 1

Work Order ID: 70725

Parent Item: D2012-105

Parent Item Name: Arm



Start Date: 6/13/2011

Required Date: 6/15/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: I02.04.03 Added Inspect level 3 NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.035

Purchased

No

100

f

234.7796

2.6254

27.63579



304 RD Tube .500 x .035W



SB 4/6/05

Location

Loc Qty

Loc Code

MAT017

234.779638

115535

2.33

116720

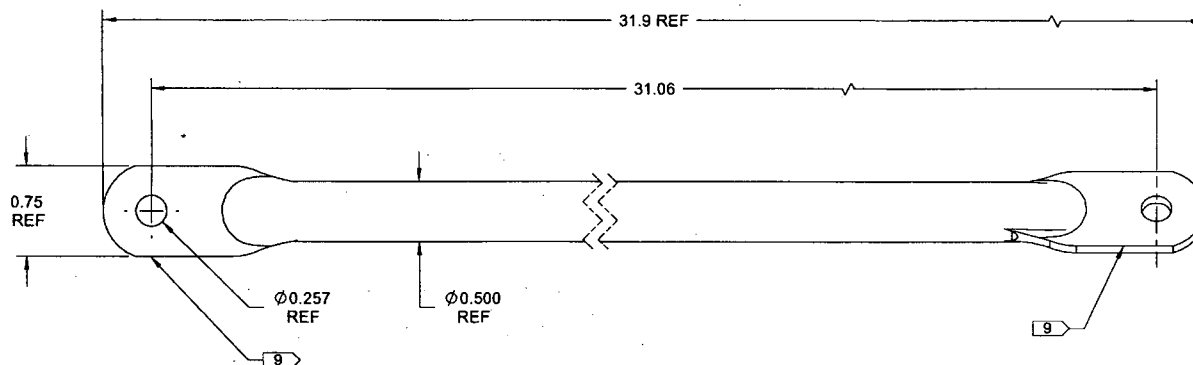
1.66068

117598 -

230.788958

M118702

6
22



D2012-105 ARM

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE Ø0.500 X 0.035 WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC: M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2012-105" USING REMOVABLE TAG
- 7) WEIGHT: 0.47 lbs
- 8) MAKE PER TEMPLATE DT8116
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

E	REFORMAT DWG, ANGLE DIMENSION POSITION AND VALUE CHG: 35° WAS 30° (ZN C2-1), PER NCR 09-060	CP	09.06.04
D	ADDED TEMPLATE & SPEC CNTRL DWG, REDRAWN IN CAD, ADD FINISH	KE	98.04.28
C	CORRECTED VIEWS PER TSR A374	KE	97.09.03
B	30° ANGLE ROTATED 60° CCW	JB	96.06.25
A	NEW ISSUE, DRAWN FROM D2012	H	92.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JB		
CHECKED	JB	DRAWING NO.	REV. E
MFG. APPR.	JB	D2012-105	SHEET 1 OF 1
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	ARM	NTS
DATE	09.06.04	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

